

Date: Wednesday, 06/09/2006 11:05:23 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASS'Y
Job Number : 28424	
Estimate Number : 12522	
P.O. Number : N/A	Part Number : D35311
This Issue : 06/09/2006 S.O. No. : N/A	Drawing Number : UNDER REVIEW E 06.09.05
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : N/A
Previous Run : N/A	Material : N/A
Written By : E	Due Date : 13/09/2006 Qty: 2 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 06-09.06 EC	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.3972 sf(s)/Unit Total : 0.7944 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M19380

M 06 09 06

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: Pre

Prog Rev: Pre

M 06 09 06

(2)

2-Deburr if necessary

M 06 09 06

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 09 06

(2)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

E 06.09.06

(2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SR 06/09/06

(2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/07/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 28424

Part Number: D35311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

EB

06/09/07

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

g.m. 06-09-14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EB 06.09.14 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock for eng. use only

Location: _____

EB 06.09.19 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

EB 06.09.19 (2)

Job Completion



W 06.09.20

PART WENT TO HAI. PART NOT APPROVED AND NOT AIRWORTHY
CB 07.07.13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-09-07	6.1	QC 5 need for bend inspection. Perm. change						
		QC 5 inspect bend.	J	06-09-07	2			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

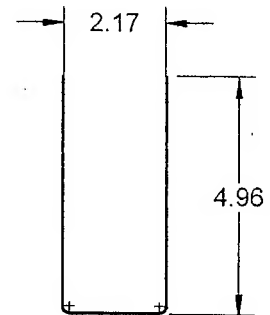
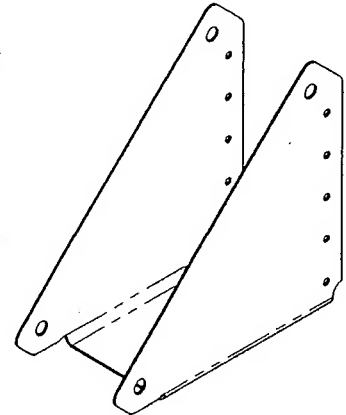
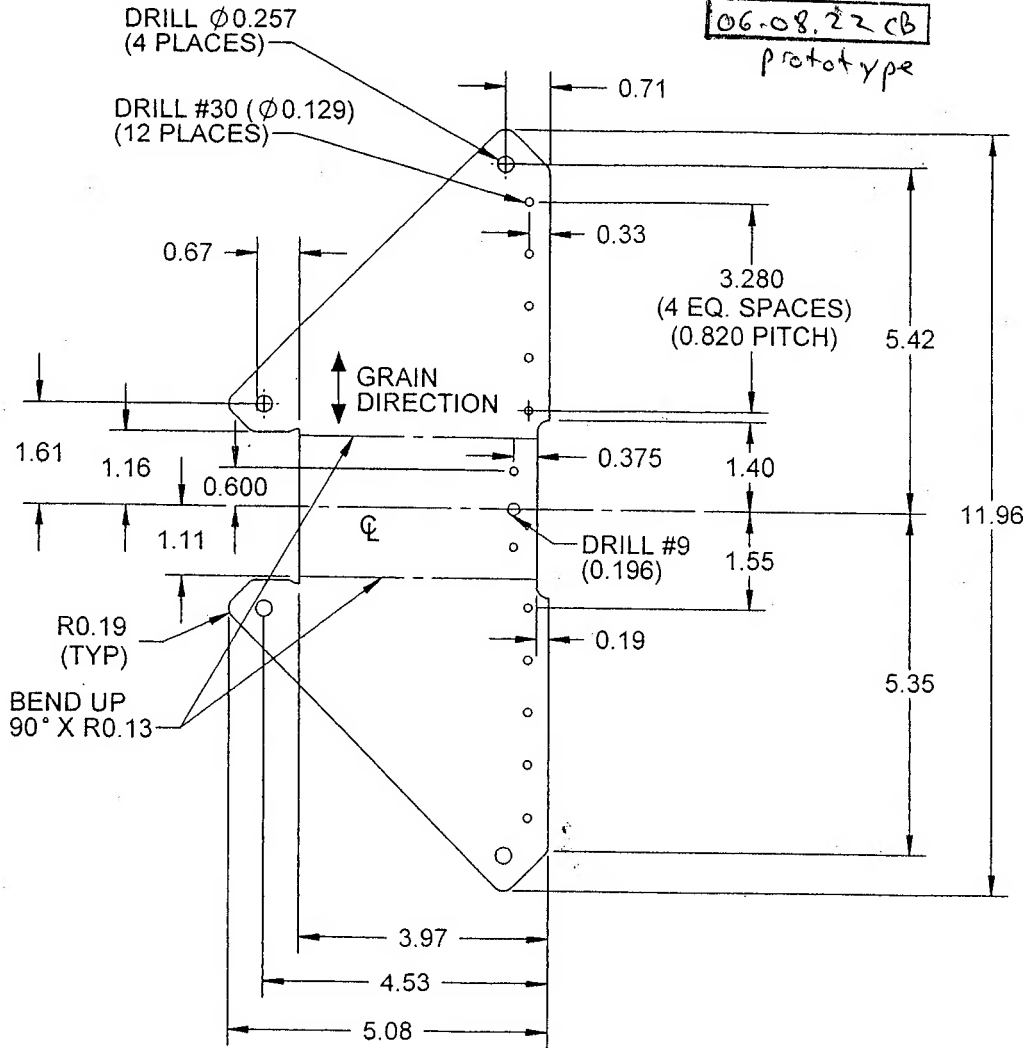
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 06.06.21	TITLE BRACKET ASSEMBLY		SCALE 1:3

UNDER REVIEW

06.08.22 CB

prototype



D3531-1 BEND DETAIL

D3531-1F FLAT PATTERN

D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ~~6061T6~~ ALUMINUM (QQ-A-250/11) 0.040 SHEET
(REF: DART-SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT ϕ

EST. Done
Proc

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DOC : V/0080151422

DATUM : 2005-04-18

PROD. REF. : 0000175932/001

NRBST : 58848/01

PAGINA : 1/ 1

KEURINGSRAPPORT



Corus Aluminium N.V.
A. Stodestaen 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

KLANT : COPPER AND BRASS SALES
CORPORATE SERVICES DIVISION
SOUTHFIELD, MI USA

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)
ONS ORDERNUMMER : 58848/01
DOCUMENT NUMMER : V/0080151422

SPECIFICATIES: ALU SHEETS (STENC.) AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
AFMETINGEN : 144" X 48" X 0,04"
ARTIKEL NR.:

ROL- NUMMER	GEUT- NUMMER	CHEMISCHE ANALYSE (%)								
		MIN	SI	FE	CU	MN	MG	CR	TI	ZN
		MAX	0,40		0,15		0,8	0,04		
			0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
001	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01
002	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01
ANDERE : ELK		:			MIN		0,05	MAX		
TOTAAL :		:			MIN		0,15	MAX		

MECHANISCHE EIGENSCHAPPEN				
1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI				
/A = ACHTER	/M = MIDDEN	/V = VOOR	/O = RANDOM	
TEST- NUMMER		RM KSI	RP02 KSI	A %
	MIN	42	35	10
	MAX			
001	/A	47	39	16
001	/M	47	39	15
001	/V	47	39	16
002	/A	47	39	16
002	/M	48	40	16
002	/V	48	39	16

COPPER AND BRASS SALES

SOLD TO: CBSDATE: 12/16 QTY. 20CUSTOMER PO: 00000024SHIPPER NO: 4V3428BY: 8

1938-0